Work Order ID 100779

100779

May 1, 2013 7:17:01 AM

Item ID: D3535-23 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Wearshoe

Start Date: 5/24/13 **Start Qty:** 12.00 *12*

Required Date: 5/24/13 **Req'd Qty:** 12.00 *12*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** 13-05-1 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Work Center	Operation Description	Est Hrs / Run Hours	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**							
D3535	Rev B							
100	FLOW WATER JET	0.00						
100					13	0		JM13-6-12
Waterjet	**Memo**	0.00						
FLOW CNC Waterjet	1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-Deburr if necessary							
304.040								
110	QC2- Inspect parts off machine FAI/FAIB	0.00						
110					13	0		JM13-6-12
QC	**Memo**	0.00						
Quality Control								
120	QC8- Inspect parts - second check	0.00						
120					(13)			DAS 09 5-8
QC	**Memo**	0.00				13-06-12		
Quality Control								

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 100779

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May 1, 2013 7:17:01 AM

Item ID: D3535-23 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Wearshoe

Start Date: 5/24/13 **Start Qty:** 12.00 *12*

Required Date: 5/24/13 **Req'd Qty:** 12.00 *12*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID / Work Center ID	Operation Description	Set Up/ Run Hours	Plan ID	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00						
130	NC BRAKE				13x			3/6/12
Brake NC								
Brake NC	**Memo**	0.00						
	1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT83262-Form joggle as per Dwg D3535 using Jig DT81583-Identify as D3535-23							
140	QC5- Inspect part completeness to step on W/O	0.00			13			
140								
QC	**Memo**	0.00						
Quality Control								
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00						
150								
Powdercoat	**Memo**	0.00						
Powder Coating	START TIME: 8:45 OVEN TEMPERATURE: 400F FINISH TIME: 9:15							

13X ✓ MF 13/06/17

M21279

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Crushed/Crimped
- ☐ Cuffs
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- ☐ Torque Waves in Extrusion
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- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 100779

May 1, 2013 7:17:01 AM

100779

Item ID: D3535-23 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Wearshoe

Start Date: 5/24/13 **Start Qty:** 12.00 *12*
Required Date: 5/24/13 **Req'd Qty:** 12.00 *12*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start** *NR1*
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Work Center ID	Operation Description	Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location FP-002	0.00							
170									
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	**Memo**	0.00							
Quality Control									

13 x ϕ BL 13/06/17

B ϕ BL 13-6-17.

13/6/17

MCJ 13-06-17

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

May 1, 2013 7:17:01 AM

Work Order ID: 100779

Parent Item: D3535-23

Parent Item Name: Wearshoe

Start Date: 5/24/13 **Required Date:** 5/24/13

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	327.9000	**1.3615**	~~17.197895~~ 18			JM 3-6-12

Location	Loc Qty	Loc Code
[illegible]	327.9	
[illegible]29	[illegible]	
124956	210.75	124956

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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- Quality ☐
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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
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Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
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DART AEROSPACE LTD	Work Order:	160779
Description: Wearshoe	Part Number:	D3535-23
Inspection Dwg: D3535 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.891"	–		V	JKM01
2.000	+/-0.010	2.000"	–		V	
4.750	+/-0.010	4.753"	–		V	
9.500	+/-0.010	9.503"	–		V	ProdWJ02
14.250	+/-0.010	14.250"	–		T	JKM06
17.750	+/-0.010	17.750"	–		T	
23.140	+/-0.010	23.140"	–		T	
28.530	+/-0.010	28.530"	–		T	
33.920	+/-0.010	33.920"	–		T	
39.310	+/-0.010	39.310"	–		T	
44.700	+/-0.010	44.700"	–		T	
48.200	+/-0.010	48.200"	–		T	
52.850	+/-0.010	52.850"	–		T	–
Ø0.188	+0.005/-0.001	Ø.190"	–		V	
48.00	+/-0.030	48.00"	–		T	
39.00	+/-0.030	39.00"	–		T	
32.00	+/-0.030	32.00"	–		T	
24.00	+/-0.030	24.00"	–		T	
16.00	+/-0.030	16.00"	–		T	
8.00	+/-0.030	8.009"	–		V	
6.00	+/-0.030	6.004"	–		V	
0.300	+/-0.010	0.304"	–		V	
0.300	+/-0.010	0.302"	–		V	
0.038	+/-0.010	0.037"	–		V	

Measured by:	JM	Audited by:	DAS 09 2-89	Prototype Approval:	N/A
Date:	13-6-12	Date:	130612	Date:	N/A

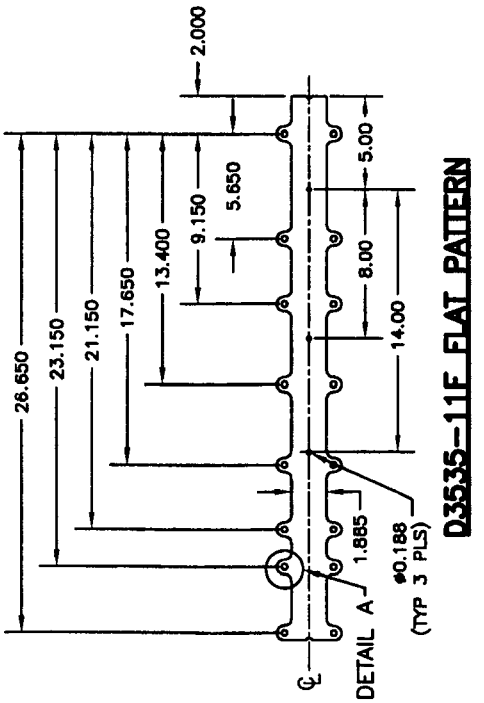
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. / REV.
		D3535 / B
DATE	TITLE	SHEET 1 OF 7 / SCALE
07.04.17	WEARSHOE	1:10

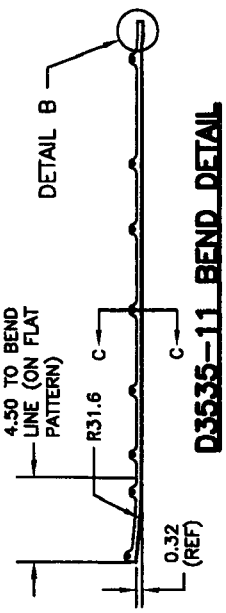
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

RELEASED
07.04.24

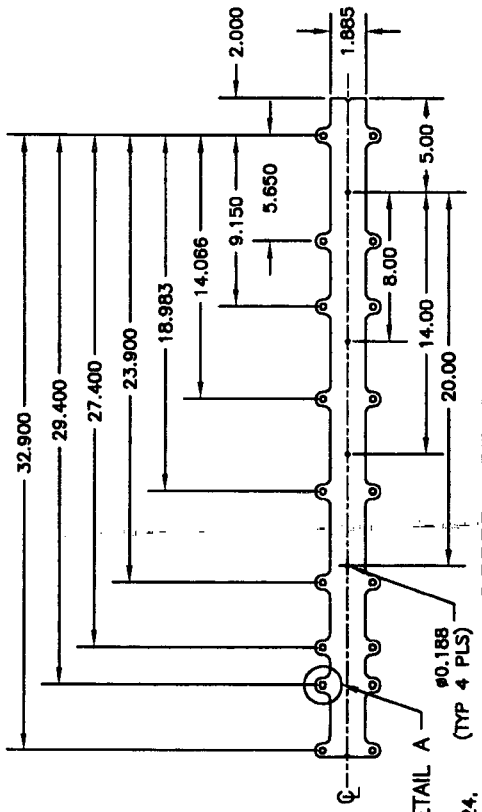
10079
rl 13-05-1



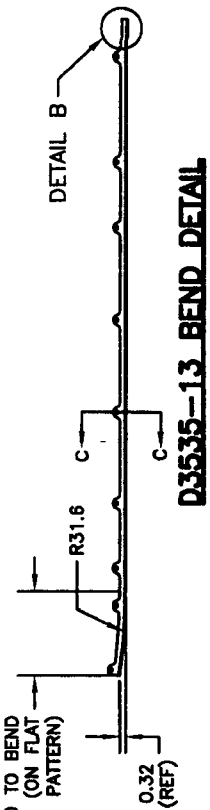
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



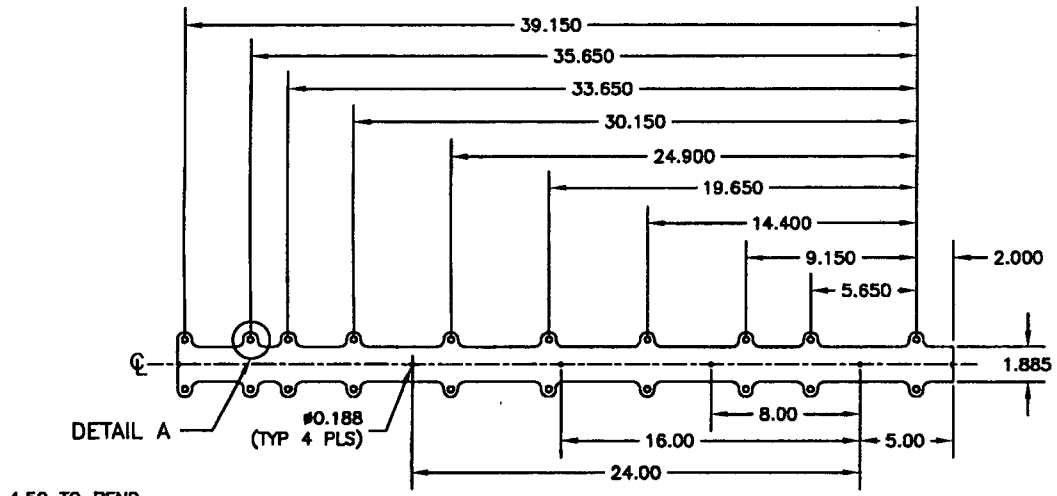
D3535-13F FLAT PATTERN



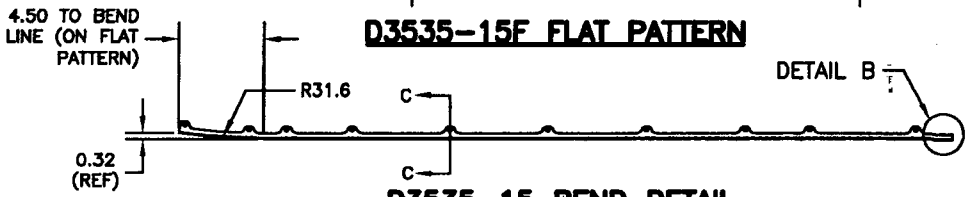
D3535-13 BEND DETAIL

NOTES
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

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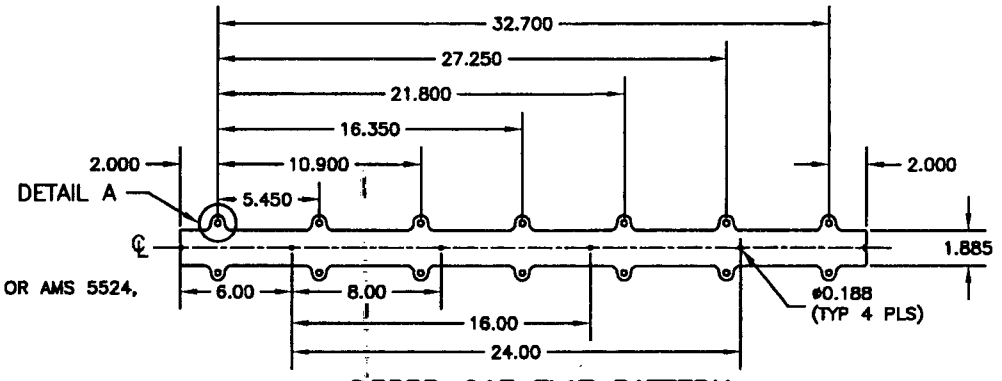
D3535-15F FLAT PATTERN



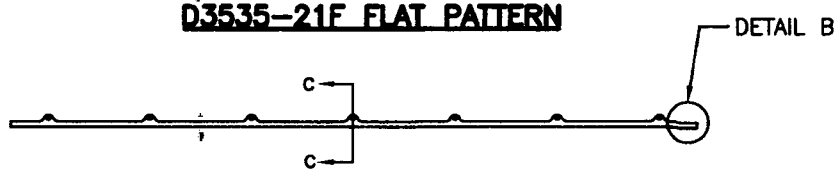
D3535-15 BEND DETAIL

106779

RELEASED
07.04.24



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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DART

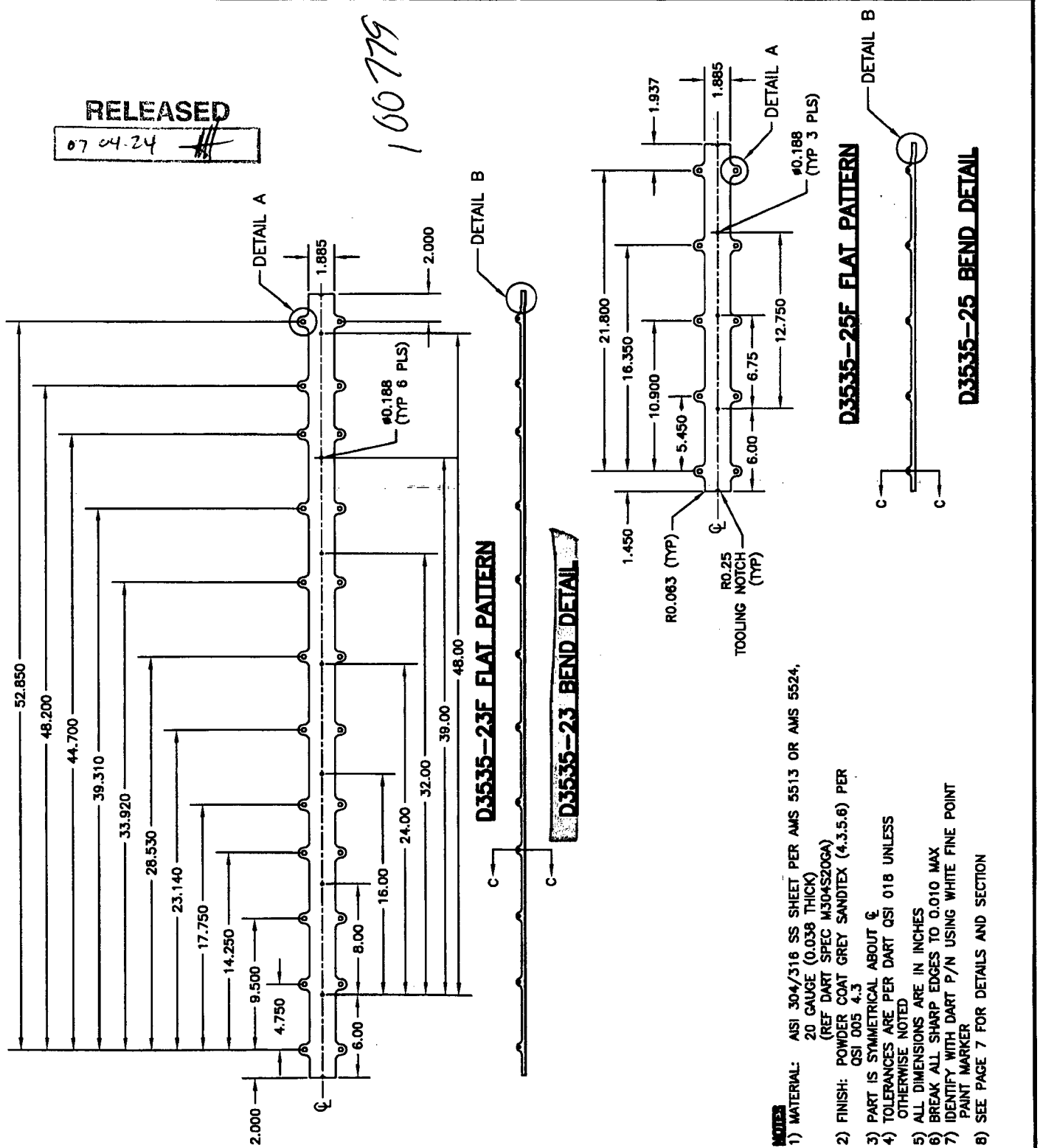
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
C.B	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 2 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. B
		D3535 SHEET 3 OF 7
DATE		TITLE SCALE
07.04.17		WEARSHOE 1:10

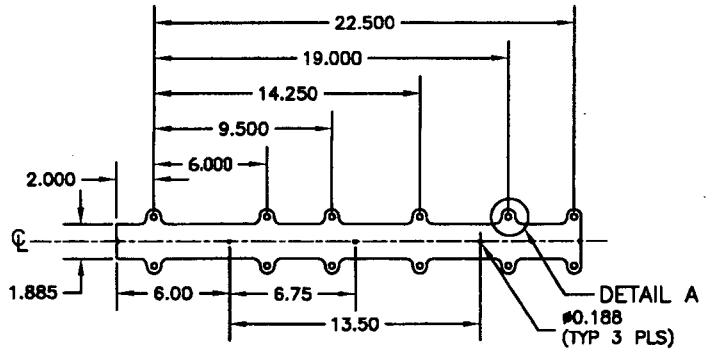
RELEASED
07.04.24

160779



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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
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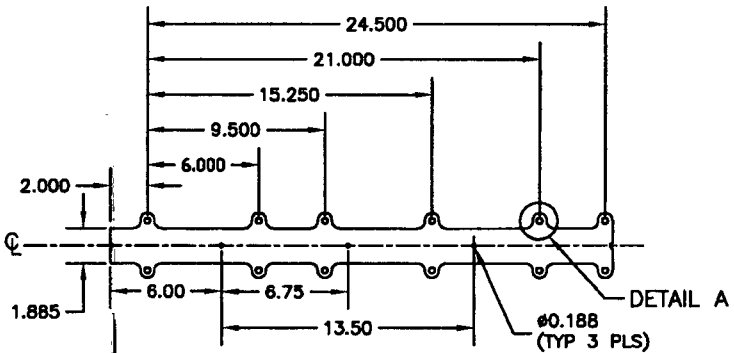
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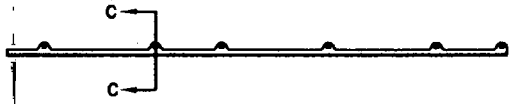
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D3535-33 BEND DETAIL

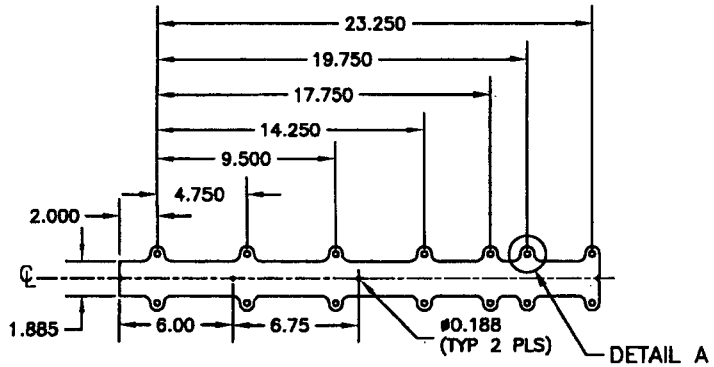
NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

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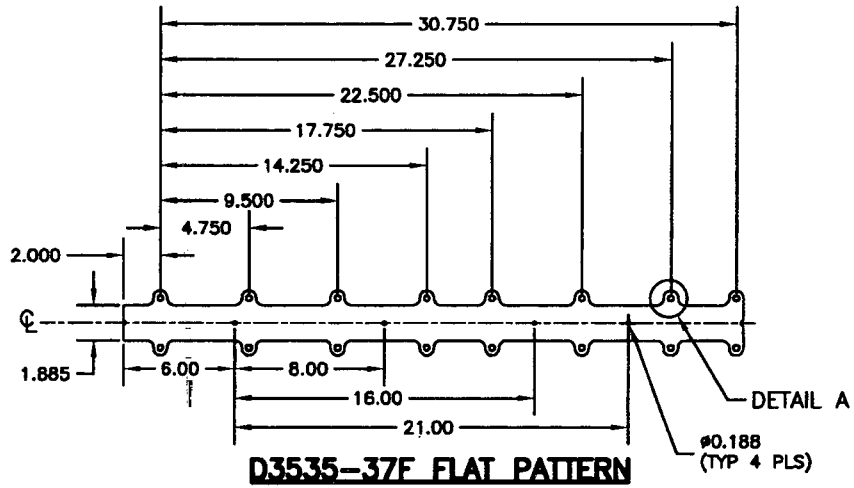
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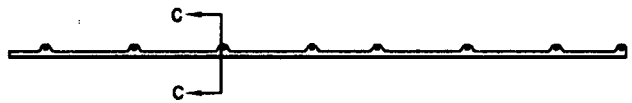
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D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

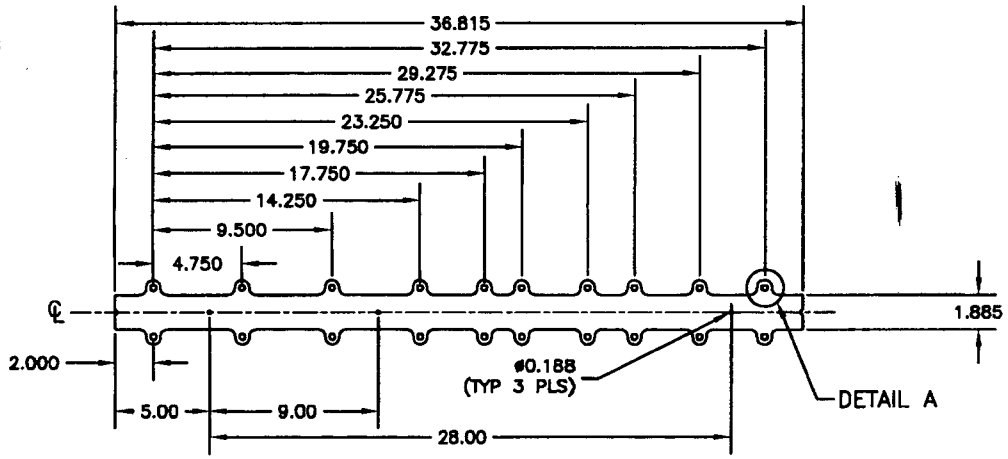
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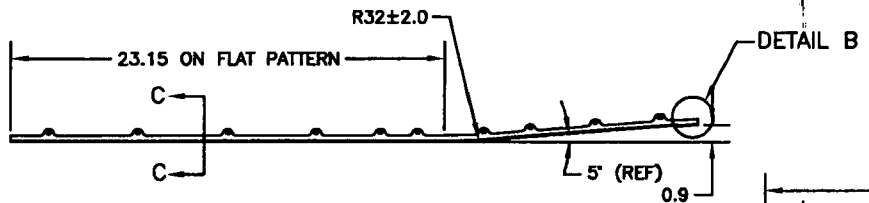
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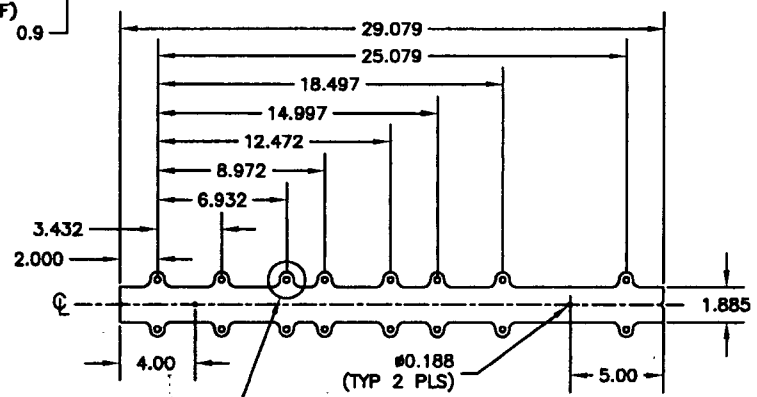
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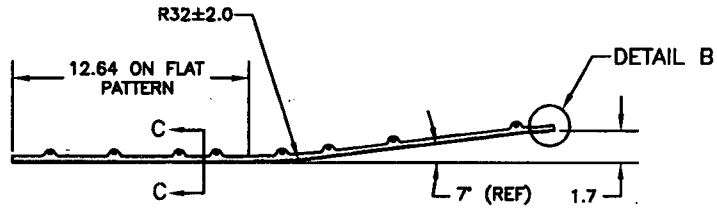
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D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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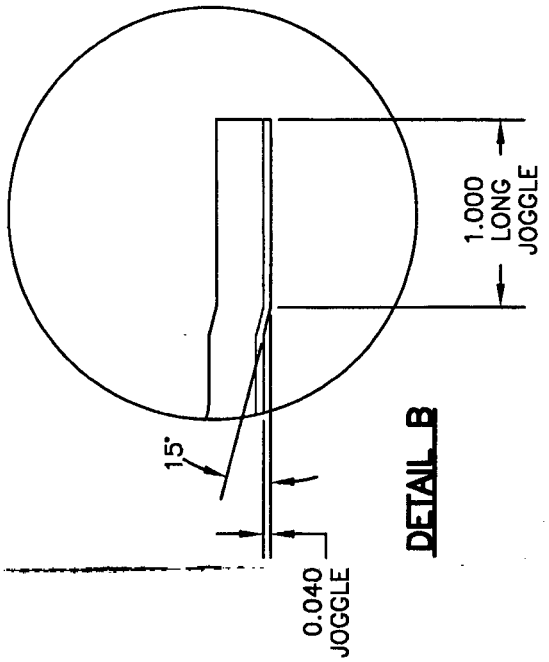
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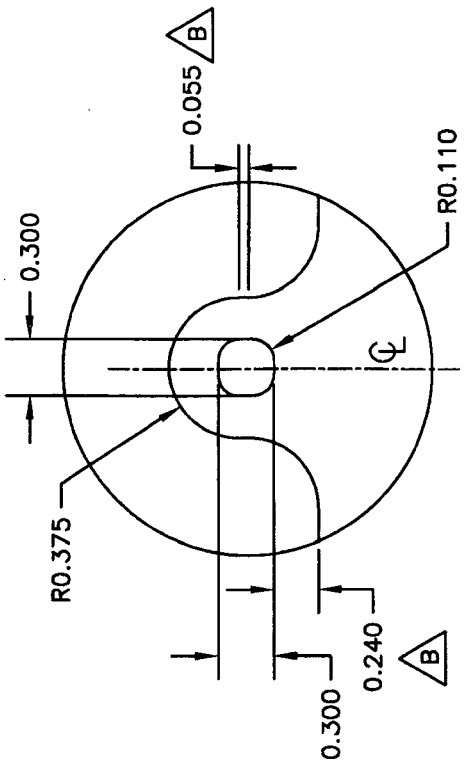
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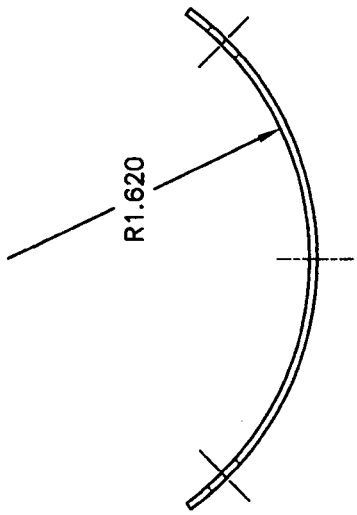
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DETAIL B



DETAIL A



SECTION C–C

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